Work Order ID 77525 *77525*

December-12-11 3:00:47 PM

Item ID: D3838-041 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID: **Stop** *NS2*

Item Name: Rib Assembly (Basket Lid, LH)

Start Date: 12/12/2011 **Start Qty:** 3.00 *3* **Cust Item ID:**

Required Date: 16/12/2011 **Req'd Qty:** 3.00 *3* **Customer:**

Reference:

Run Start *NR1*

Approvals: **Process Plan:** M.L.J **Date:** 11/12/12 **Tooling:** ______ **Date:** ______

QC: ______ **Date:** ______ **SPC (Y/N):** ______ **Date:** ______

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp

Draw Nbr	Revision Nbr
D3838	Rev A

100 — 0.00

100 Large Fab — Large Fab

(x6) Ø [signature] 12·01·23

Large Fab

Large Fab

Memo 0.00

1- cut D3838-1 and D3838-3 rib as per dwg D3838

2- remove identification markings

3- deburr → Ae 12·01·21

4- weld D3838-1 to D3838-3 and drill hole (3/16") using DT9437 jig and open to finish size as per dwg D3838
A/R ER316 S.S. Rod Batch: M115778

5- c'sink hole as per dwg

6- grind weld flush where indicated on dwg D3838

7- weld D3759-1 bushing as per dwg D3838
A/R ER316 S.S. Rod Batch: M115778

8- grind bushing weld flush as per dwg dwg D3838

9- deburr hole if necessary

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________ **PAR #:** ______ **Fault Category:** ____________ **NCR:** Yes No **DQA:** _____ **Date:** ______

Resolution: ____________ **Disposition:** ____________ **QA: N/C Closed:** ________ **Date:** ______

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 77525 *77525*

December-12-11 3:00:47 PM

Item ID: D3838-041 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID:

Item Name: Rib Assembly (Basket Lid, LH) **Stop** *NS2*

Start Date: 12/12/2011 **Start Qty:** 3.00 *3* **Cust Item ID:**

Required Date: 16/12/2011 **Req'd Qty:** 3.00 *3* **Customer:**

Reference:

Run Start *NR1*

Approvals: **Process Plan:** ______ **Date:** ______ **Tooling:** ______ **Date:** ______

QC: ______ **Date:** ______ **SPC (Y/N):** ______ **Date:** ______

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC9- Inspect visual per QSI004- Fusion Welds **Memo**	0.00 0.00	GPC 12-01-24			6x	Ø		
140 *140* QC Quality Control	QC5- Inspect part completeness to step on W/O **Memo**	0.00 0.00	S 12/01/24			(x6) -041			
150 *150* Packaging Packaging	Identify as per dwg & Stock Location: ______ Basket Cell **Memo**	0.00 0.00				SJ 12.01.23 6x			

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ PAR #: _______ Fault Category: __________________ NCR: Yes No DQA: _____ Date: _________

Resolution: ____________________ Disposition: ____________________ QA: N/C Closed: __________ Date: _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 77525 *77525*
December-12-11 3:00:47 PM

Item ID: D3838-041 **Accept** *N900040100* **Setup Start** *NS1*
Revision ID:
Item Name: Rib Assembly (Basket Lid, LH) **Stop** *NS2*

Start Date: 12/12/2011 **Start Qty:** 3.00 *3* **Cust Item ID:**
Required Date: 16/12/2011 **Req'd Qty:** 3.00 *3* **Customer:**
Reference:

Run Start *NR1*
Stop *NR2*

Approvals: **Process Plan:** ________ **Date:** ________ **Tooling:** ________ **Date:** ________
QC: ________ **Date:** ________ **SPC (Y/N):** ________ **Date:** ________

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160*	QC21- Final Inspection - Work Order Release	0.00					12/1/25		
QC Quality Control	Memo	0.00							

12-01-25
(6

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** __________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

Resolution: ____________________ **Disposition:** _____________________ **QA: N/C Closed:** __________ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
			Corrective Action Section B					
DATE	STEP	Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector

NOTE: Date & initial all entries

Picklist Print

December-12-11 3:00:51 PM

Work Order ID: 77525 *77525*

Parent Item: D3838-041 *D3838-041*

Parent Item Name: Rib Assembly (Basket Lid, LH)

Start Date: 12/12/2011 **Required Date:** 16/12/2011

Start Qty: 3.00 **Required Qty:** 3.00

Comments: IPP Rev:A 08-12-01 new issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3759-1 *D3759-1* Bushing		Manufactured	No				Each	297.0000	**	3	AJ	12·01·23	
M304TS0.750W.065 *M304TS0.750W.065* 304 SQ Tube .75x.75x.065W		Purchased	No			100	f	326.4874	1.0317 **	3.258	Ae	12·01·21	

D3759-1 locations:

Location	Loc Qty	Loc Code	
WA005	297		
66489	2		
72316	14		
74443	80		
74783	201		6x

M304TS0.750W.065 locations:

Location	Loc Qty	Loc Code	
MAT018	304.8232585		
~~117636~~	67.9987		6.516
118773	236.824559		
WA007	15.5974906		
116267	14.628472		
116763	0.9690186		
WA035	6.0667		
118181	6.0667		

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ______________ **PAR #:** ______ **Fault Category:** ______________ **NCR:** Yes No **DQA:** _____ **Date:** ________

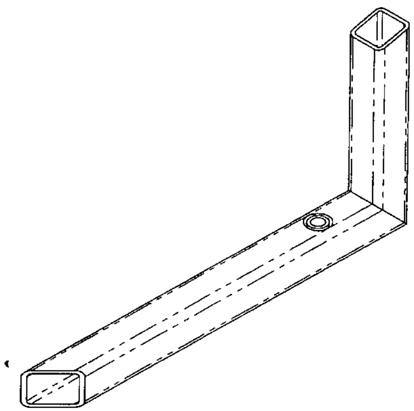
Resolution: ______________ **Disposition:** ______________ **QA: N/C Closed:** ________ **Date:** ________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
			Corrective Action Section B					
DATE	STEP	Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector

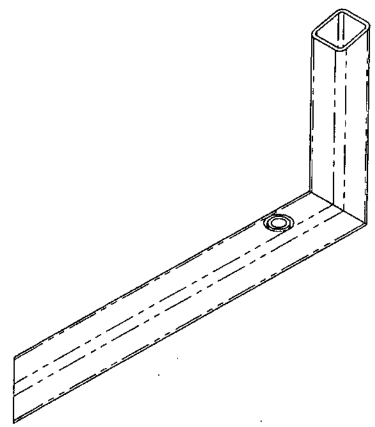
NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

ITEM	QTY -041	QTY -042	P/N	DESCRIPTION
1	X		D3838-041	RIB ASSY (BASKET LID, LH)
2		X	D3838-042	RIB ASSY (BASKET LID, RH)
3	1	1	D3759-1	BUSHING
4	1		D3838-1	RIB
5		1	D3838-2	RIB
6	1	1	D3838-3	RIB



D3838-041 RIB ASSY (BASKET LID, LH)



D3838-042 RIB ASSY (BASKET LID, RH)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 77525 M.C.J
11/12/12

RELEASED 08/11/12

NOTES:
1) MATERIAL: N/A
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.54 lbs

REV.	DESCRIPTION	BY	DATE
A	NEW ISSUE	MB	08.10.08

DESIGN	
DRAWN	
CHECKED	
MFG. APPR.	
APPROVED	
DE APPR.	
DATE	08.10.08

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D3838 — REV. A — SHEET 1 OF 3

TITLE: RIB ASSY (BASKET LID) — SCALE: NTS

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

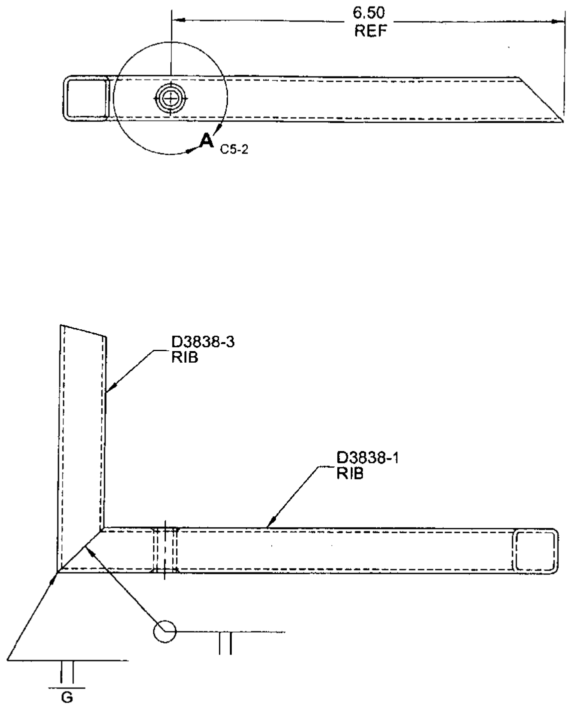
Part No: ____________ **PAR #:** ______ **Fault Category:** ____________ **NCR:** Yes No **DQA:** _____ **Date:** ________

Resolution: ____________ **Disposition:** ____________ **QA: N/C Closed:** ________ **Date:** ________

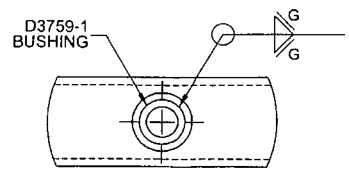
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
			Corrective Action Section B					
DATE	STEP	Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector

NOTE: Date & initial all entries

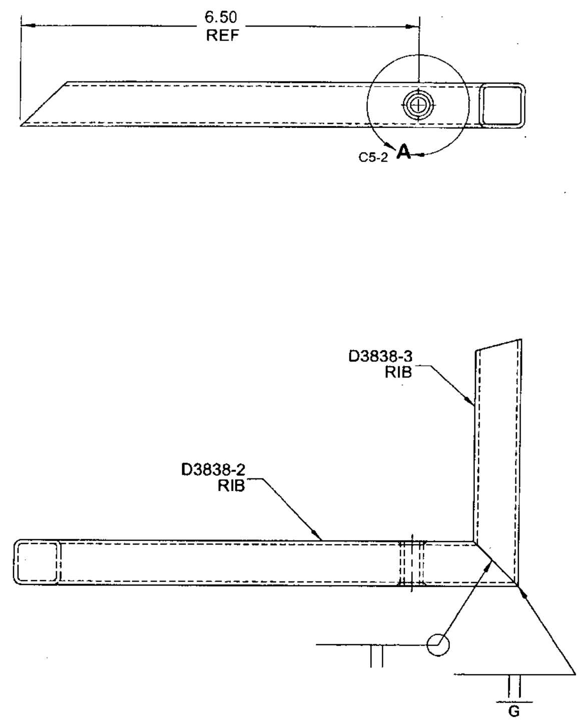
77525



D3838-041 RIB ASSY (BASKET LID, LH)



D2-2
D7-2 **DETAIL A**
SCALE 2X



D3838-042 RIB ASSY (BASKET LID, LH)

RELEASED 08/11/18

DESIGN		**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN		
CHECKED		DRAWING NO. D3838 — REV. A — SHEET 2 OF 3
MFG. APPR.		
APPROVED		TITLE RIB ASSY (BASKET LID) — SCALE NTS
DE APPR.		
DATE	08.10.08	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

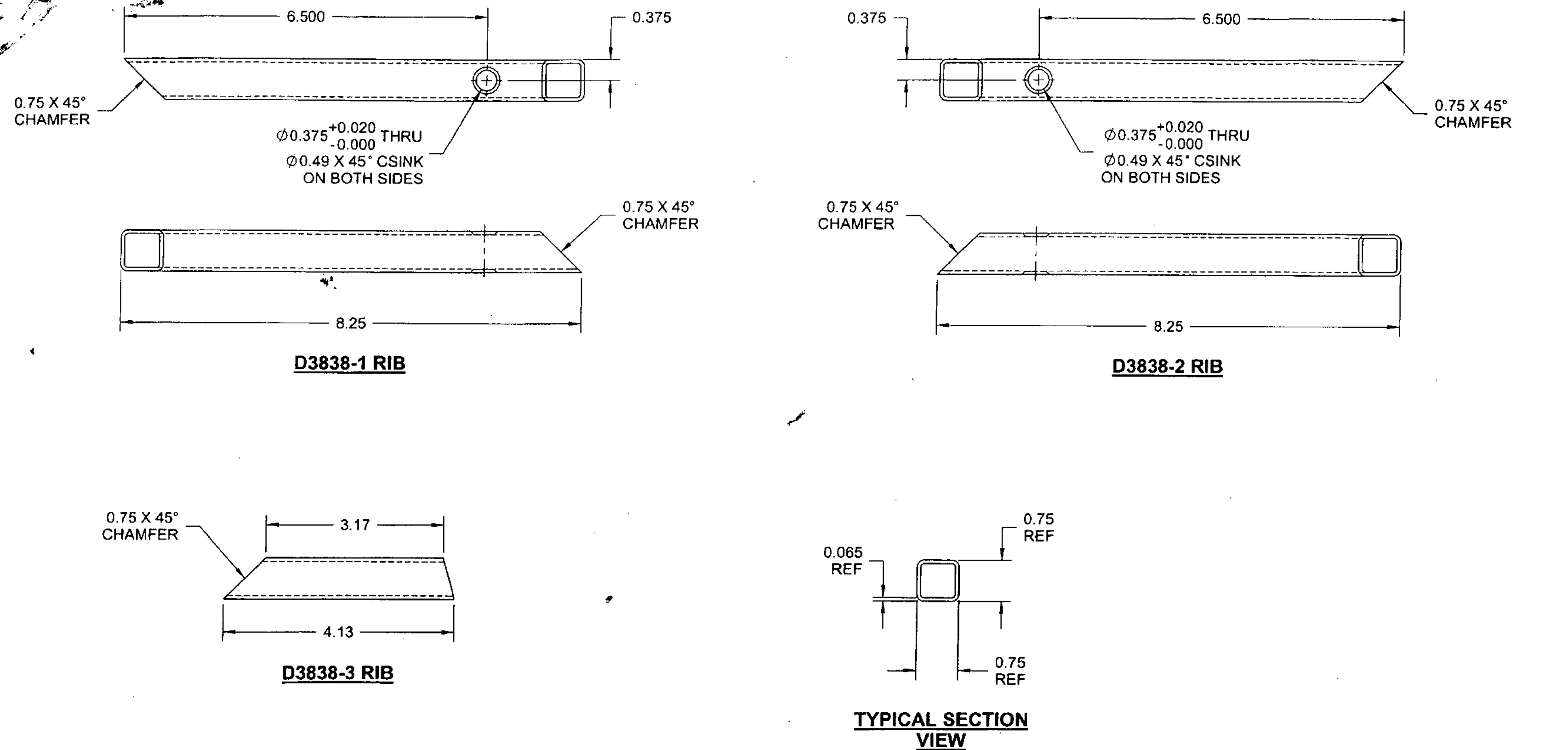
Part No: ____________________ PAR #: _______ Fault Category: __________________ NCR: Yes No DQA: _____ Date: _________

Resolution: ____________________ Disposition: ____________________ QA: N/C Closed: __________ Date: _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

77525



RELEASED

NOTES:
1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL
REF. DART SPEC. M304TS0.750W0.065
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: D3836-/-2 = 0.35 lbs EACH; D3836-3 = 0.19 lbs

DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN		
CHECKED		DRAWING NO. D3838 — REV. A — SHEET 3 OF 3
MFG. APPR.		
APPROVED		TITLE: RIB ASSY (BASKET LID) — SCALE NTS
DE APPR.		
DATE	08.10.08	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** ____________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

Resolution: ____________________ **Disposition:** ____________________ **QA: N/C Closed:** _________ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries